December 8, 2009 11:25:22 AM

Required Date: 16/12/2009

Item ID:

D3763-6

Tube

Accept

Setup Start

Stop



Page 1

Revision ID:

Start Date:

Item Name:

08/12/2009

QC:

Start Qty: 10.00 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date.

Date:_

Tooling:

SPC (Y/N):

Date: Date:

Start Run

Stop



Sequence ID/ Work Center ID Operation Description Set Up/ **Run Hours** Draw Number Draw Rev.

Plan Code

Accept Qty

Reject Reject Number **Qty**

Insp. Stamp

Draw Nbr D3763

Rev B

Revision Nbr

100

Doosan

Doosan Lathe

DOOSAN LATHE

0.00

0.00

per dwg D3763

110

QC2- Inspect parts off machine FAI/FAIB

09/12/28

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

St 09/12/28

Memo

0.00

Quality Control

Dart Aeı	rospace	e Ltd								1
W/O:			W	ORK ORDE	R CHANGE	S				
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										*3
					*• .				,	g i.
-					4_*					
										•
**				*****						
Part No	:	PAR #:	Fault Cat	tegory:		NCR: Yes	No DQ	A :	Date: _	
	R	esolution:	Dispositi	on:		QA: N/C C	osed:		Date: _	
NCR:		1	WORK ORI	DER NON-CO	ONFORMAI	NCE (NCF	₹)			
		Description of NC		Corrective Ac	tion Section	n B	Vorifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng		Description ef Eng	Sign & Date)	tion C	Chief Eng	QC Inspector
									1	

NCR:			WOIN ONDE	III IIOII-OOIII OIIMAII								
	1	STEP Description of NC Section A		Corrective Action Section B	Verification	Approval	Approval					
DATE STE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector				
					:							
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					į							
•												

NOTE: Date & initial all entries

Work Order ID 54371

Page 2

December 8, 2009 11:25:22 AM

Item ID: **Revision ID:** D3763-6

Tube

Accept

Setup Start



Item Name: Start Date:

08/12/2009

Start Qty: 10.00 Req'd Qty: 10.00

Operation

Description

Cust Item ID:

Customer:

Draw

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop



Required Date: 16/12/2009

Date:

SPC (Y/N):

Date:

Draw

Stop

Reject



Insp.

Sequence ID/ Work Center ID

130

Packaging

Memo

Memo

Identify as per dwg & Stock Location 25 | A

0.00

0.00

Run Hours

Set Up/

Number Rev. Ćode Qty

Plan

Qty Number Stamp

Reject

Packaging

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Accept

Dart	Aeros	space	Ltd

		———							
W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		•							etu.
	ļ								
 -	<u> </u>								
Part No:		PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	A :	Date: _	
	R	esolution:	Disposition	n:	QA: N/C C	osed:		Date: _	· · · · · · · · · · · · · · · · · · ·
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC		on B	Verific	cation	Approval	Approval	
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector
									i
. ,									
								,	

NOTE: Date & initial all entries

Picklist Print

December 8, 2009 11:25:29 AM

Work Order ID: 54371

Parent Item:

Comments:

D3763-6

Parent Item Name: Tube



Start Date: 08/12/2009

Required Date: 16/12/2009

Page 1

Start Qty: 10.00

Required Qty: 10.00

										<u> 1 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 </u>		
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6R1.250 Purchased		No			100	f	28.1121	2,2979				
0001-10 Round But 1.230				Warehous	Se.	Loc	Otv	Loc Code	ŀ			

<u>Warehouse</u>	Loc Qty	Loc Code		
Location				
Main Warehouse				
MAT	28.1121			
108876	9.6			
109733	7.04			
111321	9.1021			
18295	2.37			

113457

2.298 SL 09/12/28

Dart Aerospace Ltd

		_								
W/O:			WO	RK ORDER CHAN	GES			· · · · · · · · · · · · · · · · · · ·		
DATE	STEP	PRO	OCEDURE CHAI	IGE	E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No: PAR #:		Fault Categ	ory:	NCR:	Yes N	o DQ	A :	_ Date: _		
Resolution:			Disposition]:	QA: N	/C Clos	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	MANCE (NCR)				
DATE	STEP	Description of NC	Corrective Action Sect				Verific	ation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
						1 111				
					!					
					,					
						 				
				•						
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	1		1 1				1			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 3437/	
Description: Tube	Part Number: D3763-6	
Inspection Dwg: D3763 Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

	X	First Artic	le _	Proto	type			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Metho		Com	nments
2.62	+/-0.030	2.619						
0.655	+/-0.010	-654						
Ø0.221	+0.005/-0.001	-222						
0.655	+/-0.010	.654						
0.05 x 45°	+/-0.030 x +/-0.5°	-05 X45°						
10°	+/-0.5°	100						
90°	+/-0.5°	900	/					
Ø1.010	+0.010/-0.000	1.012						
Ø1.16	+/-0.030	7.160						
Ø0.323	+0.006/-0.001	.324						
						_		
,								
		-				-		
Measured by:	77	Audited by:	13		Proto	type A	pproval:	N/A
Date:	09/12/28	Date:	02/12/2	/			Date:	N/A
Rev Date	Change					Revis	ed by	Approved
A 08.09.04	New Issue				_	KJ/DE		78

Ø0.221 REF

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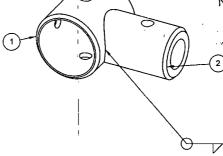
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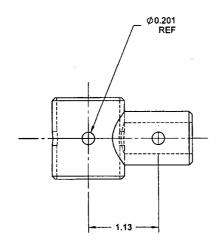
UNCONTROLLED Code

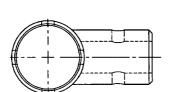
SUBJECT TO AMPISO 11 11

WITHOUT A 1 A 1

WORK 437/ NO 5437/ BP0912-8

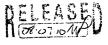






ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3763-3	TUBE	1
2	D3763-1	FITTING .	1

D3763-041 END FITTING ASSY

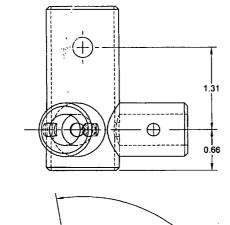


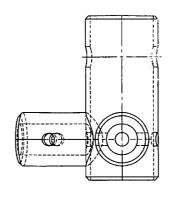
В	CHANG	E HOLES SIZE	ADD -7 PART AND -045 ASSY	HŞ	08.06.23			
Α	NEW IS	SUE		HS	08.06.04			
REV.			DESCRIPTION	BY	DATE			
DESIGN HS		HS	DART AEROS	DART AEROSPACE LTD				
DRAW	DRAWN HS		HAWKESBURY, ONTARIO, CANADA					
CHECK	(ED	RH	DRAWING NO.		RÉV. E			
MFG. A	PPR.	$X \cap$	D3763	SHEET 1 OF				
APPRO	OVED		TITLE		SCALE			
DE AP	DE APPR.		END FITTING		NTS			
DATE 08.06.23			COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPERTING AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONDETOR COMMISSATED TO ANY OTHER PERSON WITHOUT					

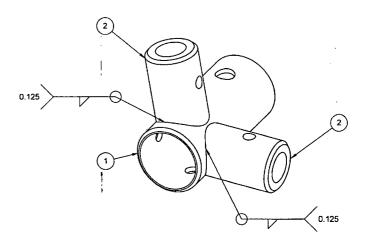
	<u> </u>
1	MATERIAL: N/A
- 2 5	

1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs
8) WELD: PER DART QSI 004

3







	100°
1.13	
1	.13 ——

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-5	TUBE	1
2	D3763-1	FITTING	2

D3763-043 END FITTING ASSY, LH

VOTES:

1) MATERIAL: N/A

2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

1) UNITS: INCHES UNLESS OTHERWISE NOTED

3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

3) IDENTIFICATION: N/A

') WEIGHT: 0.05 lbs

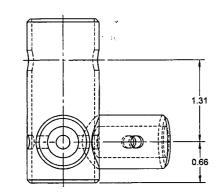
3) WELD: PER DART QSI 004

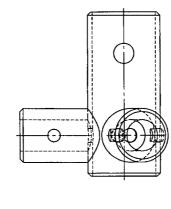
DESIGN HS DART AERÓSPACE LTD DRAWN HS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3763 MFG. APPR. SHEET 2 OF 9 APPROVED TITLE SCALE **END FITTING** DE APPR. NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD
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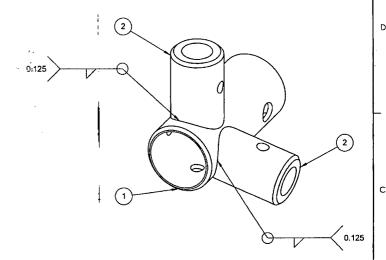
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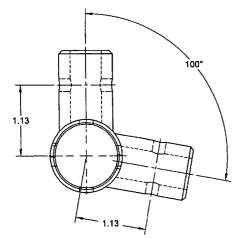
3

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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-6	TUBE	1
2	D3763-1	FITTING	2

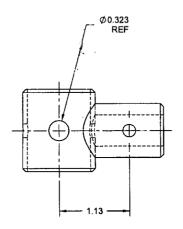
D3763-044 END FITTING ASSY, RH

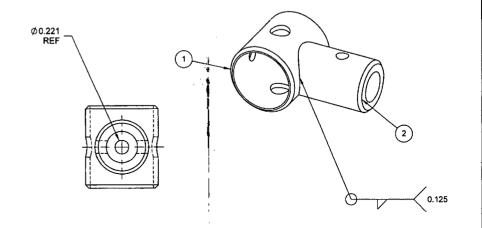
3

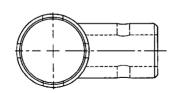
DESIGN HS DÁRT AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN HS CHECKED DRAWING NO. REV. B D3763 MFG. APPR. SHEET 3 OF 9 APPROVED TITLE SCALE **END FITTING** DE APPR NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD
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NOTES:

1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
2) FOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
3) UNITS: INCHES UNLESS OTHERWISE NOTED
3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
3) IDENTIFICATION: N/A
4) WEIGHT: 0.05 lbs
3) WELD: PER DART QSI 004







ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3763-7	TUBE	1
2	D3763-1	FITTING	1

D3763-045 END FITTING ASSY

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs
8) WELD: PER DART QSI 004

DESIGN HS DART AEROSPACE LTD DRAWN HS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3763 MFG. APPR. SHEET 4 OF 9 APPROVED TITLE SCALE **END FITTING** DE APPR. NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD
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WHITTEN PROVISION FROM CONT. AEROSPACE. DATE 08.06.23

3

Ø 0.50 THRU R0.580 ∠0.06 x 45° CHAMFER ALL AROUND Ø0.860^{+0.000} 1.090 Ø0.201 🔊 -0.05 X 45° CHAMFER - 0.545 -

D3763-1 FITTING

NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)

(OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-7
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A 7) WEIGHT: 0.02 lbs

DESIGN HS DART AEROSPACE LTD DRAWN HS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3763 MFG. APPR SHEET 5 OF 9 APPROVED TITLE SCALE **END FITTING** DE APPR. NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD
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Ø1.010^{+0.010} Ø0.221 B 0.66 Ø1.16 B ß 0.66 -0.05 X 45° CHAMFER 2 PL

D3763-3 TUBE

Ø0.201 THRU B

<u>NOTES:</u>
i) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)

(OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-/
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

DESIGN HS DART AEROSPACE LTD DRAWN HS HAWKESBURY, ONTARIO, CANADA 210 DRAWING NO. CHECKED REV. B D3763 MFG. APPR. SHEET 6 OF 9 APPROVED TITLE SCALE **END FITTING** DE APPR. NTS

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0.655 Ø0.323 THRU-2.62 ∞ Ø0.221 THRU <u>B</u> 2 PL 0.655 0.05 X 45° CHAMFER-2 PL Ø1.010^{+0.010} D3763-5 TUBE

(OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-/
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
5) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs

8

	wlo	54	DELFASE NEFOTUDIAD	
	DESIGN	HS	DART AEROSPA	CE LTD
	DRAWN HS		HAWKESBURY, ONTARIO, CANADA	
	CHECKED	世 //	DRAWING NO.	REV. B
	MFG. APPR.	150	D3763	SHEET 7 OF 9
	APPROVED	TN	TITLE	SCALE
	DE APPR.		END FITTING	NTS
	DATE 08.0	6.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IN PRIVATE AND COMPRESTIVE AND B SUPPLED ON THE EXPRÉSS CONDITION OF TO BE USED FOR ANY PHYSORE OR COMPLED ON COMMUNICATED TO ANY OTHER PERSONS FROM QUART AEROPHOLE LTD.	
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0.655 ∞ Ø0.221 THRU 2.62 2 PL 0.655 0.05 X 45° CHAMFER Ø0.323 THRU ϕ 1.010 $^{+0.010}_{-0.000}$ Ø1.16 **D3763-6 TUBE** DESIGN HS DART AEROSPACE LTD <u>40TES:</u>
I) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R) DRAWN HS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-F
!) FINISH: NONE
!) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
!) UNITS: INCHES UNLESS OTHERWISE NOTED
i) BREAK SHAP EDGES: 0.005 TO 0.010 MAX
i) IDENTIFICATION: N/A
') WEIGHT: 0.02 lbs D3763 MFG. APPR. SHEET 8 OF 9 APPROVED TITLE SCALE **END FITTING** DE APPR NTS COPYRIGHT & 2008 BY DART AEROSPACE LTD

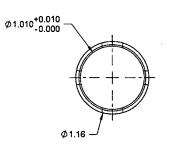
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WRITTEN PERMIESION PROC. DART ARROSPACE LTD. DATE 08.06.23

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Ø0.221 THRU 0.66

- 1.31 -





-0.05 X 45° CHAMFER 2 PL 0.66 Ø0.323 THRU

D3763-7 TUBE

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R) (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-/2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

8

DART AEROSPACE LTD DESIGN HS DRAWN HS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3763 MFG. APPR SHEET 9 OF 9 APPROVED TITLE SCALE **END FITTING** DE APPR. NTS COPYRIGHT O 2008 BY DART AEROSPACE LTD
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